

Work Order ID 110071

December-17-13 9:07:32 AM

110071

RUSH!!

Page 1

Item ID: D2281

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Jack Saddle

Stop

NS2

Start Date: 12/17/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MCS Date: 13-12-19 Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2281	Rev G

100	FLOW WATER JET	0.00				<u>20</u>	<u>0</u>		<u>Jan 14-1-4</u>
1100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2281 Dwg Rev: <u>G</u> Prog Rev: <u>G</u> 2-								
304.080"	Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00				<u>20</u>	<u>0</u>		<u>Jan 14-1-4</u>
1110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00				<u>20</u>			
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

12/1/17

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110071

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/17/13 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 12/17/13 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

Deburr

0.00

140

140

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per D2281 using D2281-T2

0.00

150

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

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Page 3

Item ID: D2281

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Jack Saddle

Stop ***NS2***

Start Date: 12/17/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Identify as per dwg & Stock Location: W/A001

0.00

160

Packaging

Memo

0.00

Packaging

20 EL 14-1-7

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

14-01-7
7/01/201414-01-7

Picklist Print

December-17-13 9:07:31 AM

Page 1

Work Order ID: 110071

Parent Item: D2281

Parent Item Name: Jack Saddle

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 304SS sheet .080		Purchased	No			100	sf	131.4500	0.125	2.631578 3.0			

Location

Loc Qty

Loc Code

MAT020

131.45

117933

4.5

119276

9.7

M126075

117.25

126075

Jm 1-4

DART AEROSPACE LTD		Work Order:	110071
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.475"	-		✓	Jkmo1
4.114	+/-0.010	4.116"	-		✓	
2.933	+/-0.010	2.940"	-		✓	
1.535	+/-0.010	1.533"	-		✓	
0.354	+/-0.010	0.356"	-		✓	
0.354	+/-0.010	0.354"	✓		✓	
0.604	+/-0.010	0.602"	-		✓	
2.000	+/-0.010	1.999"	-		✓	
3.396	+/-0.010	3.397"	-		✓	
3.646	+/-0.010	3.650"	-		✓	
4.000	+/-0.010	4.007"	-		✓	
1.525	+/-0.010	1.530"	-		✓	
2.475	+/-0.010	2.479"	-		✓	
Ø0.323	+0.006/-0.001	0.325"	-		✓	
0.080	+/-0.010	0.078"	-		✓	

DAS

27

9-89

Measured by: Jm	Audited by: DAS	Prototype Approval:	N/A
Date: 14-1-4	Date: 14/1/7	Date:	N/A

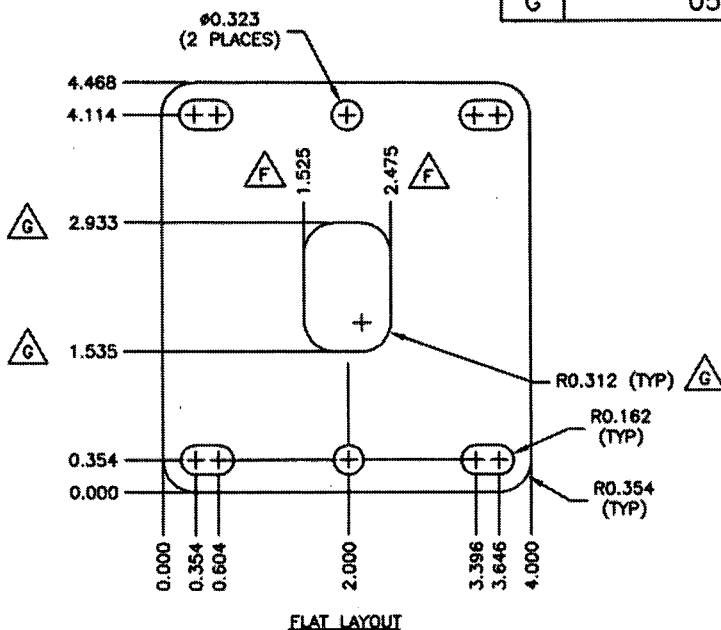
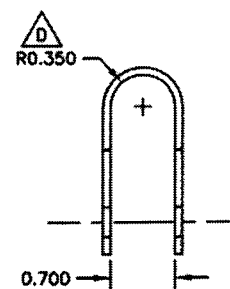
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

DART

DESIGN BW	DRAWN BY <i>FB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>WKS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED

05/08/11

110071 ML5
13-12-19**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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